

Work Order ID 77862

December-22-11 8:53:41 AM

77862

30

Page 1

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206 (24") Bearpaw
 Start Date: 22/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2432	Rev F3

120	FLOW WATER JET	0.00							
120									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								

B12-1-10

8

130	HAAS CNC VERTICAL MACHINING #1	0.00							
130									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								

R9 12-1-20

7 1

140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140									
QC	Memo	0.00							
Quality Control									

R9 12-1-20

7 0

W/O: 77862 77862		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2432 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: 12/12 Date: 12/1/25
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 12/1/26 Date: 12/1/26

NCR: 12-1151		WORK ORDER NON-CONFORMANCE (NCR) 176.55						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-1-20	# B0	Forgot to switch programs Fly cutter faces cap screw, wrecking the hole and the workpiece. RC: operator error	 12/1/20 PS/041	Scrap + no replacement blanks. Qty (41)	 12-1-20	 12/1/20	 12/1/20 PS/041	 12/1/20

NOTE: Date & initial all entries

Work Order ID 77862

77862

Page 2

December-22-11 8:53:41 AM

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206 (24") Bearpaw
 Start Date: 22/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00							
Quality Control									
151	Identify as per dwg & Stock Location: _____	0.00							
151									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/10/24
G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-22-11 8:53:45 AM

Page 1

Work Order ID: 77862

77862

Parent Item: D2432

D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	683.6443	3.7	29.6			
MUHMWB10									**				
UHMW 1" Black													

1812-10

Location

Loc Qty

Loc Code

MAT018

360

120035

360

126635

MAT019

323.6443158

117321

74.6

117738

95.8

117819

83.3

118814

1.5

119145

68.4443158

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 77862
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45	/	/		
B	5.500	+/-0.030	5.500	/	/		
C	0.200	+/-0.030	.198	/	/		
D	0.25 x 45°	+/-0.030	.25 x 45	/	/		
E	R0.250	+/-0.030	.250	/	/		
F	0.250	+/-0.010	.245	/	/		
G	0.625	+/-0.030	.630	/	/		
H	0.375	+/-0.010	.374	/	/		
I	0.950	+0.030/0.010	.950	/	/		
J	19.000	+/-0.030	19.000	/	/		
K	3.14	+/-0.030	3.140	/	/		
L	3.28	+/-0.030	3.280	/	/		
M	Ø0.260	+0.005/-0.000	.260	/	/		
N	Ø0.93	+/-0.030	.927	/	/		
O	0.30	+0.030/-0.000	.320	/	/		
P	23.750	+/-0.030	23.750	/	/		
Q	7.375	+/-0.030	7.375	/	/		
R	4.250	+/-0.010	4.250	/	/		
S	2.000	+/-0.030	2.02	/	/		
T	9.000	+/-0.010	9.000	/	/		
U	9.000	+/-0.010	9.000	/	/		
V	0.375	+/-0.010	.377	/	/		

Measured by: <i>RZ</i>	Audited by: <i>amf</i>	Prototype Approval:	N/A
Date: 12.1.20	Date: 12/01/23	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF <i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

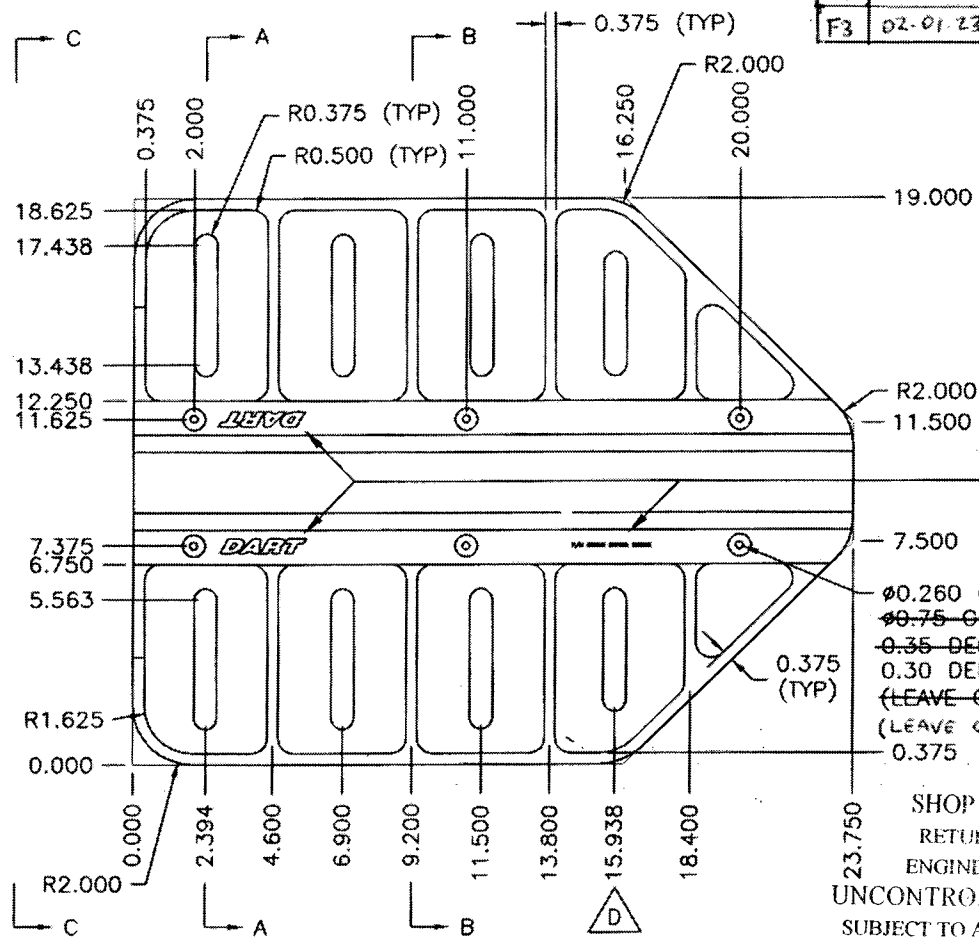
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
98.06.17 KE

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
0.375
F1 F2 F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77862 M/L

EFFECTIVE	DEOS
9143	

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM		D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE
		1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

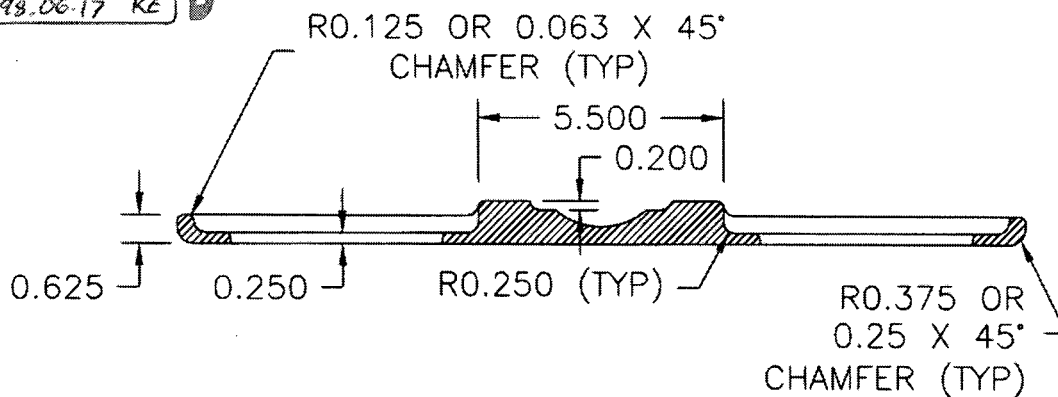
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

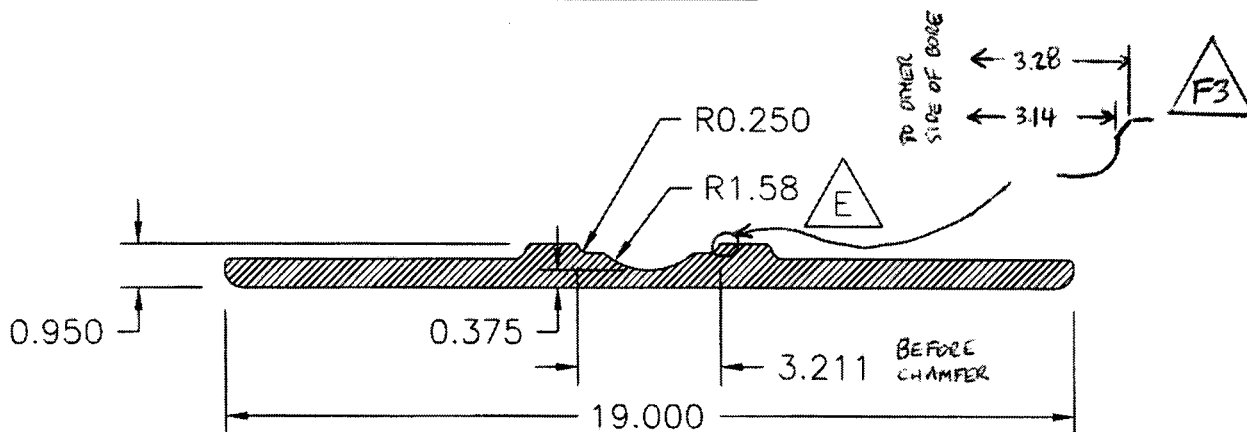


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

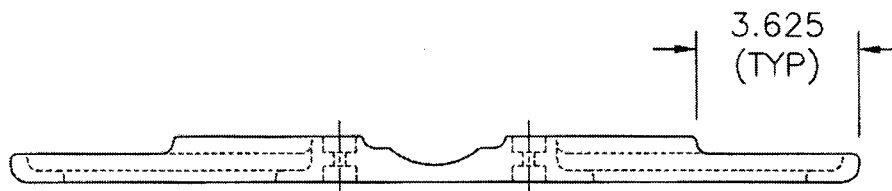
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

208tt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries